

Work Order ID 62974



Page 1

Thursday, October 14, 2010 12:42:25 PM

Item ID: D3391-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 10/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 10-10-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H

100 0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 Rev: ___ & Dwg D3391 Rev: ___

SA 10/11/30

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 10/11/30

120 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: H
2-Deburr

SA 11/02/14

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/02/14

QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00

AL 11.2.15

QC

Memo

0.00

Quality Control

150

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP

11-2-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

Form as per Dwg D3391

11-2-18

170

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

5/10/10

h=4.05"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(All holes)

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per
Dwg D3391.7- Transfer holes from D3391-013 for electric step. Open holes as per dwg D3391
section cc-cc

8-Deburr

11-2-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

205

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/11/22

7

1 0 Berthel

DP

11-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Install crossbolt spacers per dwg D3391
A/R Magnabond 6398 batch: *M116227*

2- Grind flush

*EXP 08/2011**1 0 3E 11/02/12*

220

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

11 02 24 ①

225

0.00



Pressure Wash per QSI005 4.3

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

1 0 2L 11/02/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115951

Memo

0.00

Powder Coating

START TIME: *8:50*
OVEN TEMPERATURE: *320°*
FINISH TIME: *9:20*

1 BL 11-2-08

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ 11/02/25

250

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ 1-Install inserts per dwg D3391
✓ 2-Install Aft Cap as per Dwg D3391

✓ A/R Sikaflex-241/-291 *M115114*
Sikaflex expiry date: *11/01*

1 φ 11/02/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/03/01

Quality Control

1

270

Identify as per dwg & Stock Location: w/o 0.00

Packaging

Memo

0.00

0412-742-041 / B 62962

Packaging

1 11/03/01

280

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/03/01

11-03-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, October 14, 2010 12:42:30 PM

Page 1

Work Order ID: 62974

Parent Item: D3391-015

Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 05.12.13 New issue EC
 IPP rev B 06.02.09 Dwg @ revD EC
 IPP rev C 07.03.13 dwg @revF ec
 IPP rev D 07.10.31 ecn 1053P EC
 IPP Rev:E ECN 1056 07-11-13 DD verified by: EC
 IPP Rev:F 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	29.0000	10	10			
-----------	-------------------	-----------	----	--	--	-----	------	---------	----	----	--	--	--



washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST245	29	
-------	----	--

107534	29	
--------	----	--

D6014-090		Manufactured	No			210	Each	29.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



ALUMINUM EXTRUSION

Location	Loc Qty	Loc Code
----------	---------	----------

LG	29	
----	----	--

56572	29	
-------	----	--

ALS4-1032-130		Purchased	No			250	Each	969.0000	14	14			
---------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--



Insert

Location	Loc Qty	Loc Code
----------	---------	----------

PKG11	920	
-------	-----	--

114723	920	
--------	-----	--

ST282	10	
-------	----	--

110511	10	
--------	----	--

ST381	39	
-------	----	--

114654	39	
--------	----	--

M1116304 x10 11/02/28

SA 12/11/30

11/02/25

M115581 x14

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Thursday, October 14, 2010 12:42:30 PM

Work Order ID: 62974

Parent Item: D3391-015

Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225 Purchased

No

250

Each

4,860.000

12

12



Insert



11/02/28

Location

Loc Qty

Loc Code

PK011

4860

110768

4860

ALS4-428-165

Purchased

No

250

Each

107.0000

4

4



Inserts



11/02/28

Location

Loc Qty

Loc Code

FP

7

6989

7

ST282

100

114172

100

AN3C4A

Purchased

No

250

Each

1,361.000

6

6



BOLT



11/02/28

Location

Loc Qty

Loc Code

ST303

3

115438

3

1116704

11/02/28

ST350

1358

114108

14

114416

12

114523

2

115300

330

115589

1000

Thursday, October 14, 2010 12:42:30 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item: D3391-015

Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

250

Each

1,169.000

4

4



Bolt



11/02/25

Location

Loc Qty

Loc Code

ST350

1159

114330

11

115015

16

115371

100

115422

100

115594

432

115835

500

x4

ST351

10

113121

10

D2646

Manufactured

No

250

Each

41.0000

1

1



Aft Cap



11/02/25

Location

Loc Qty

Loc Code

FP-4

36

57332

36

x1

fp5

1

61752

1

FP6

4

52663

4

Thursday, October 14, 2010 12:42:30 PM

Shop Packet Print

Page 3

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Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00


Required Qty: 1.00

D3537-1 Manufactured No 250 Each 14.0000 1 1

 Wearpad

Location	Loc Qty	Loc Code
FP	1	B65057
55465	1	
FP017	6	
61986	6	
FP17	7	
57713	3	
60491	3	
61640	1	

all 11/02/28

xl

D3537-7 Manufactured No 250 Each 15.0000 1 1

 Wearpad

Location	Loc Qty	Loc Code
FP	5	
46346	5	
FP16	10	
56831	10	

all 11/02/28

xl

D3553-1 Manufactured No 250 Each 41.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP	41	
33868	1	
56568	40	

all 11/02/28

xl

Dart Aerospace Ltd

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Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3553-3
Gasket
Manufactured No

250 Each

45.0000

1

1



all 11/02/20

Location

Loc Qty

Loc Code

FP

45

53480

45

xl

D3670-4-200
SPACER
Manufactured No

250 Each

64.0000

14

14



BE 11/02/22

Location

Loc Qty

Loc Code

LG

64

57349

64

**5*

D3672-1
Phenolic Washer
Manufactured No

250 Each

855.0000

2

2



all 11/02/20

Location

Loc Qty

Loc Code

ST077

855

42329

150

52505

705

y2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	62974
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	/		Tape	SA-1
3.500	+/-0.010	3.594	/		Vern	SA-5
88.93	+/-0.030	88.93	/		Tape	SA-1
44.995	+/-0.030					
Ø3.200	+/-0.010	3.208	/		Vern	SA-5
88.93	+/-0.030					
Ø3.750	+/-0.010	3.748	/		Vern	SA-5
30° x 160° chamfer	+/-0.010	30° x 150	/		Vern	SA-5

Measured by: SA **Date:** 12/1/30

Audited by: **Date:**

HAAS Section						
1.526	+0.000/-0.030	1.508	/		Vern CNC-02	
7.500	+/-0.010	7.499	/		"	
27.750	+/-0.010	27.750	/		m-tape	
31.750	+/-0.010	31.750	/		"	
35.250	+/-0.010	35.250	/		"	
3.300	+/-0.010	3.299	/		Vern CNC-02	
0.200	+/-0.010	.200	/		"	
3.520	+/-0.010	3.516	/		mic JLM4	
0.687	+0.010/-0.000	.693	/		Vern CNC-02	
R0.062	+/-0.010	.062	/		RG	
Ø0.484	+0.005/-0.001	.487	/		Vern CNC-02	

Measured by: SL **Date:** 11/02/14

Audited by: ML **Date:** 11-2-15

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	AS



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DRAWING ROOM

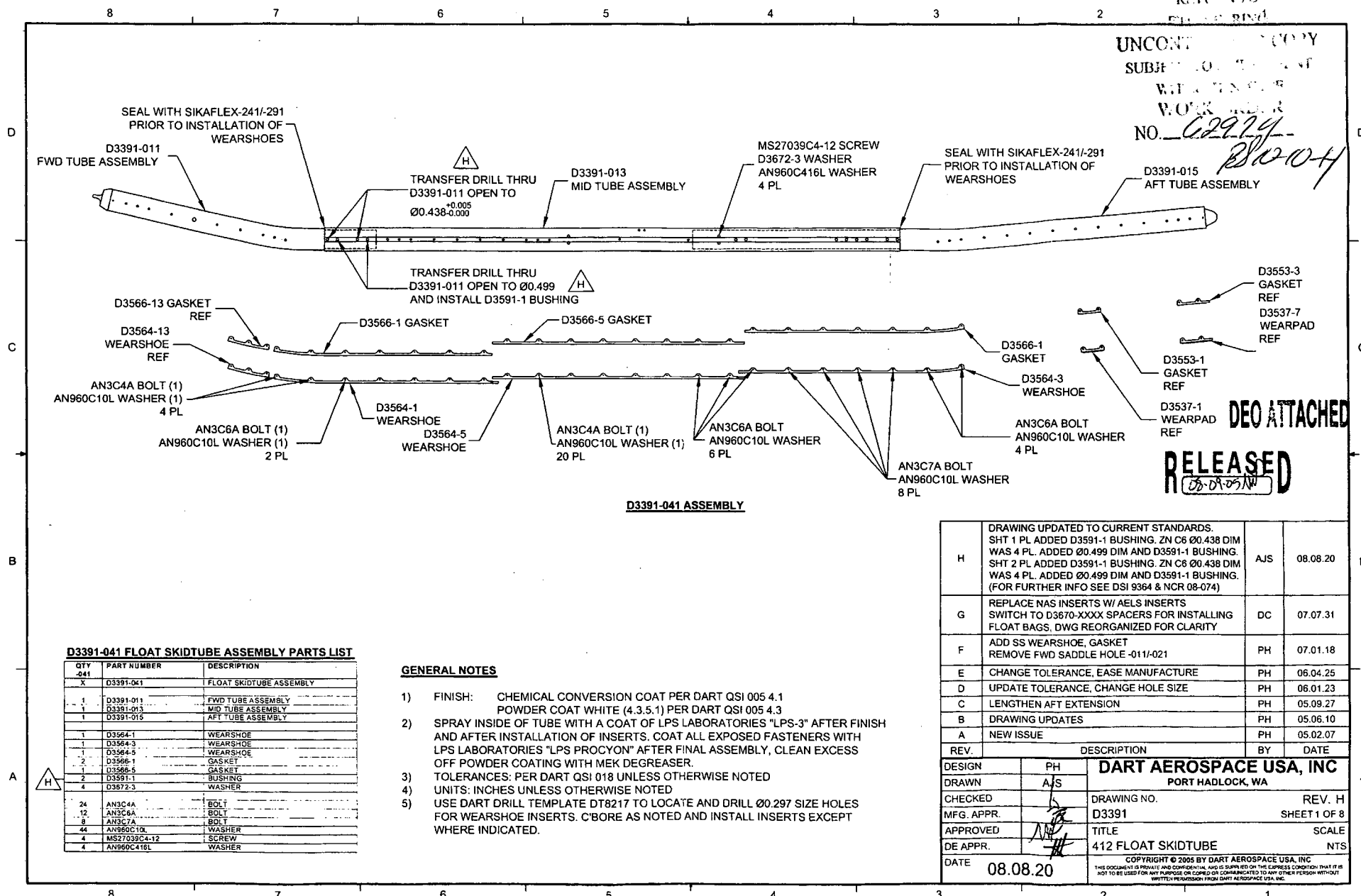
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SUBJECT: 412 FLOAT SKIDTUBE

WORK ORDER

NO. 02979

28004



RELEASED

08-09-10

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
2	D3566-13	BUSHING
4	D3572-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

REV.	DESCRIPTION	BY	DATE
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3391 412 FLOAT SKIDTUBE REV. H SHEET 1 OF 8 SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.20		

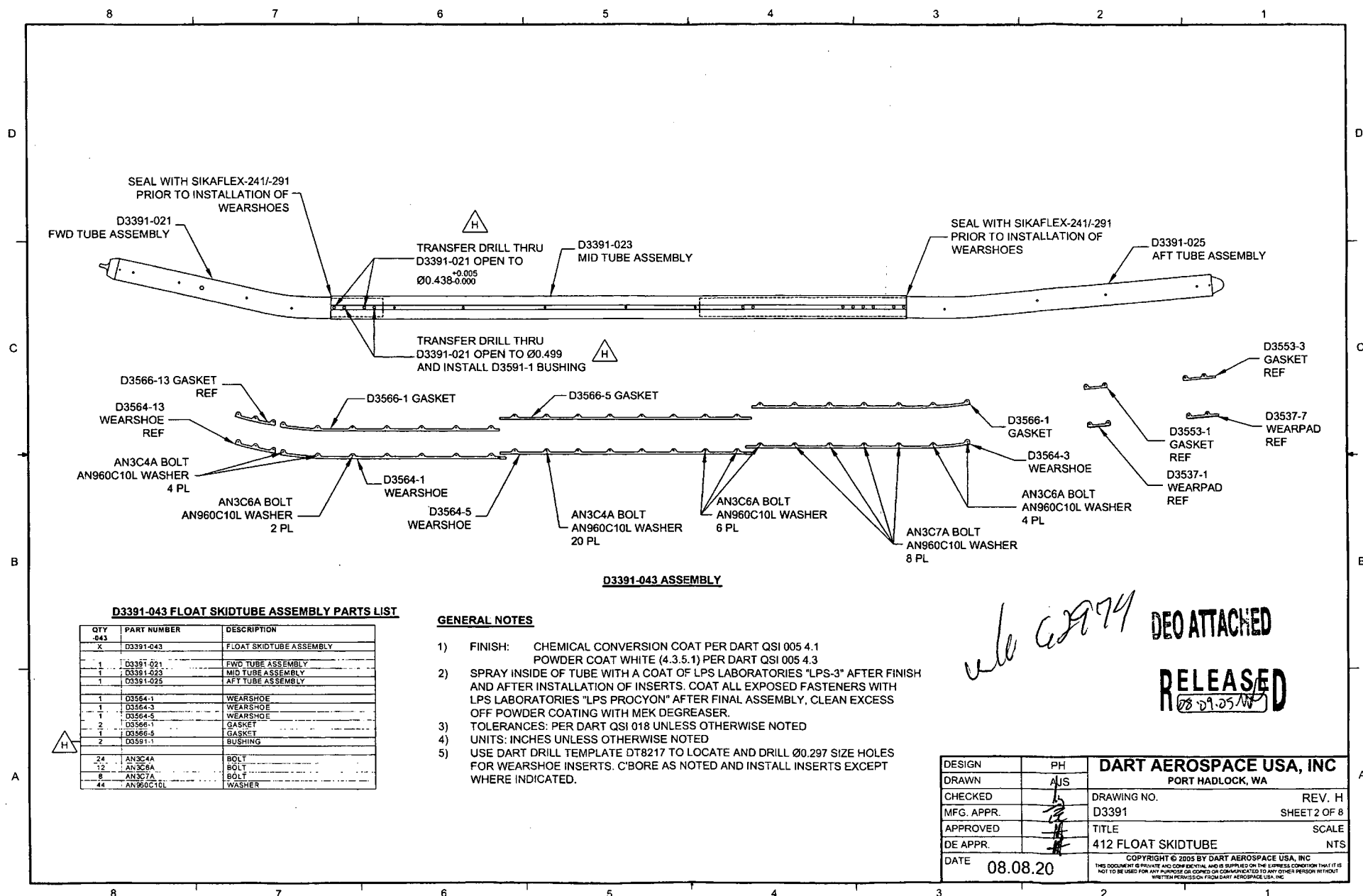
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



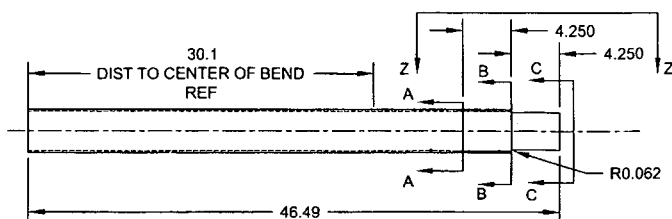
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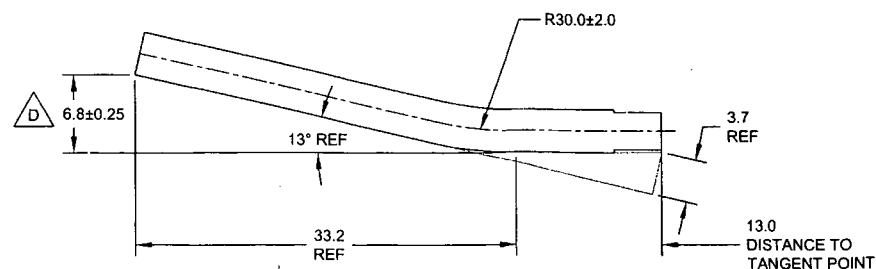
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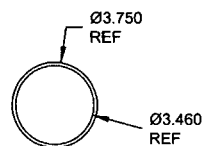
NOTE: Date & initial all entries



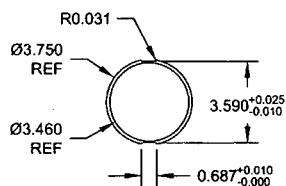
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



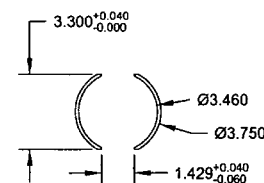
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



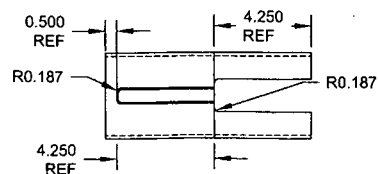
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

Handwritten signature: w/b 4/29/94

DEO ATTACHED
RELEASED
Handwritten: 08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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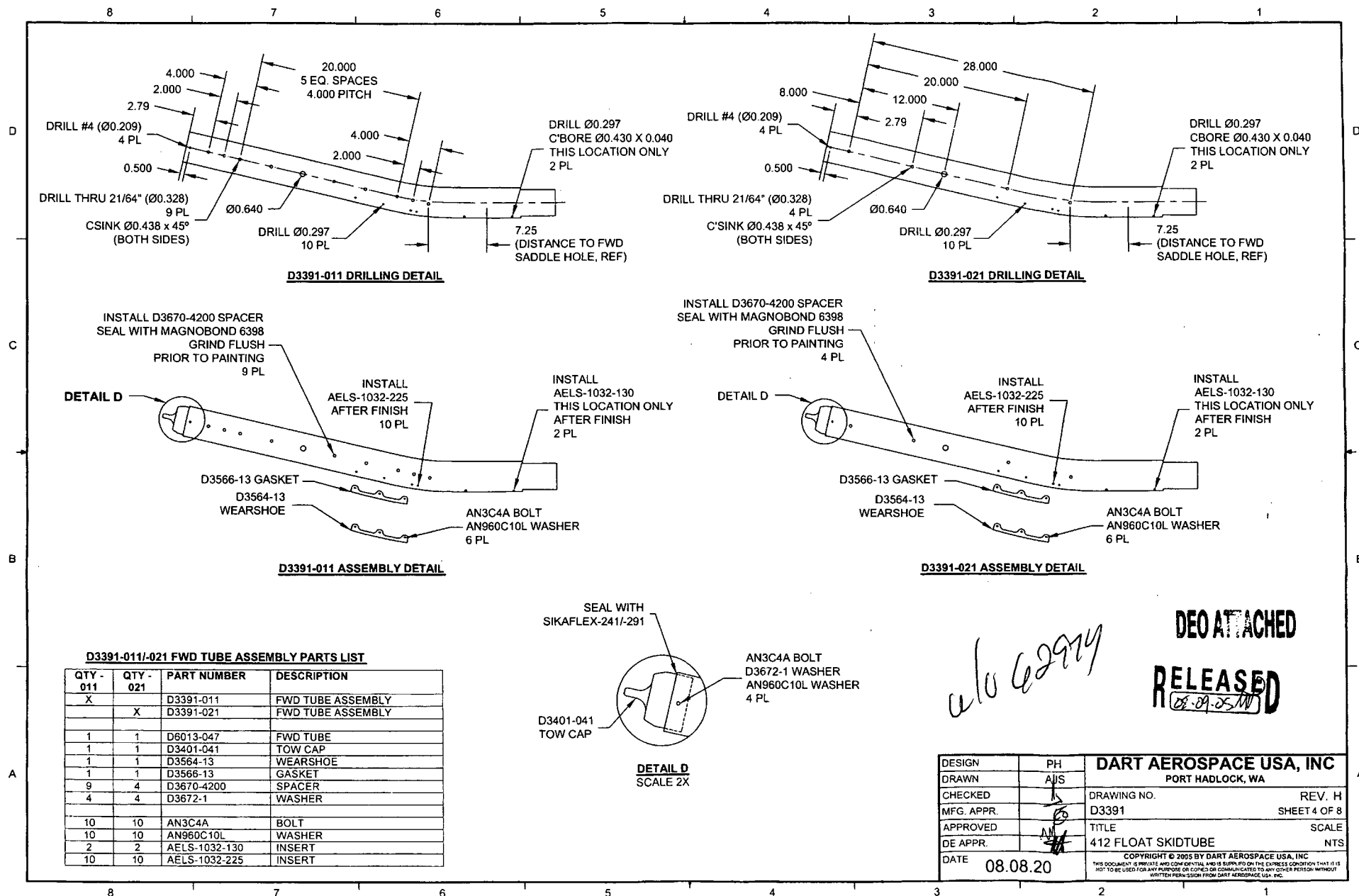
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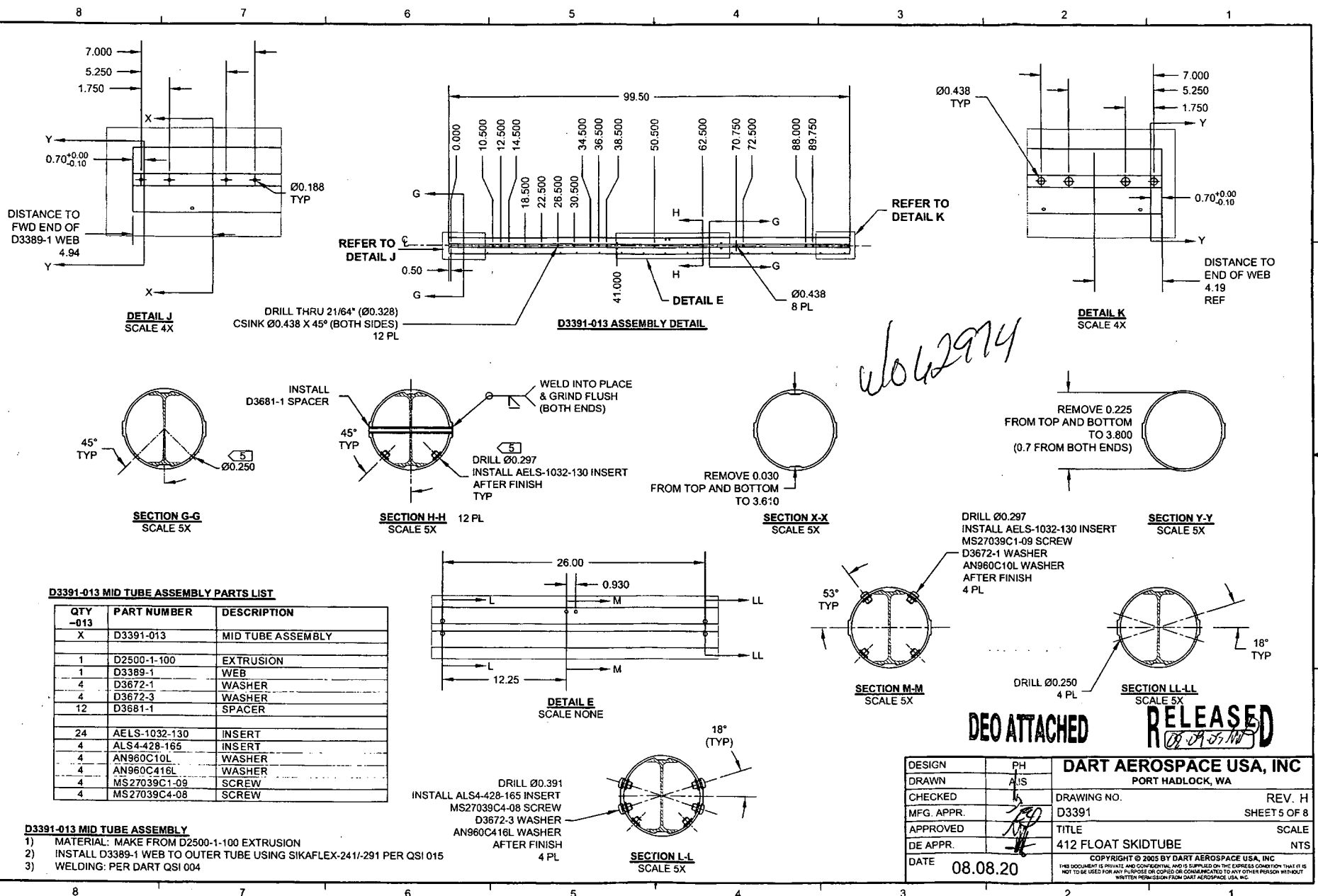
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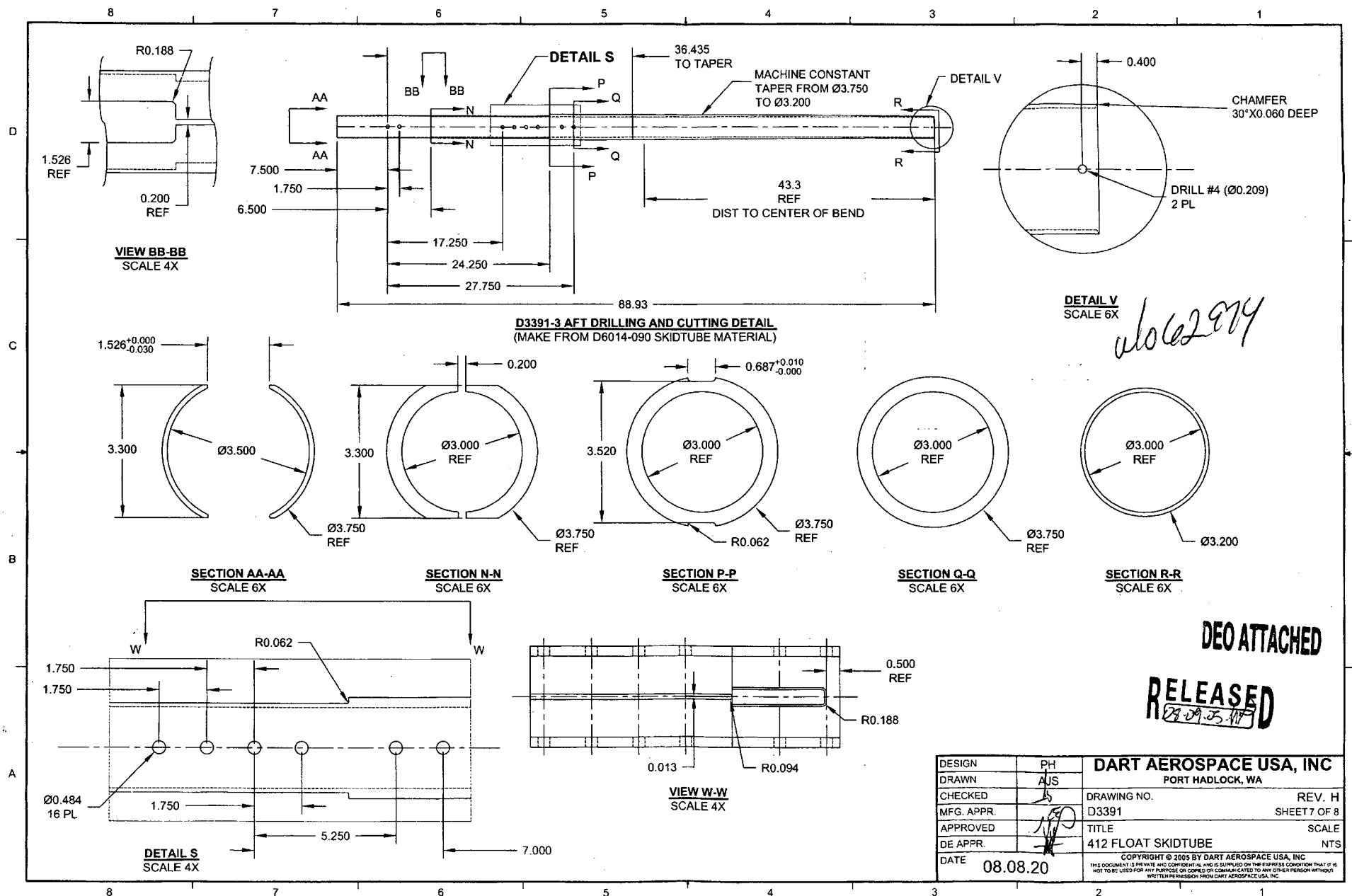
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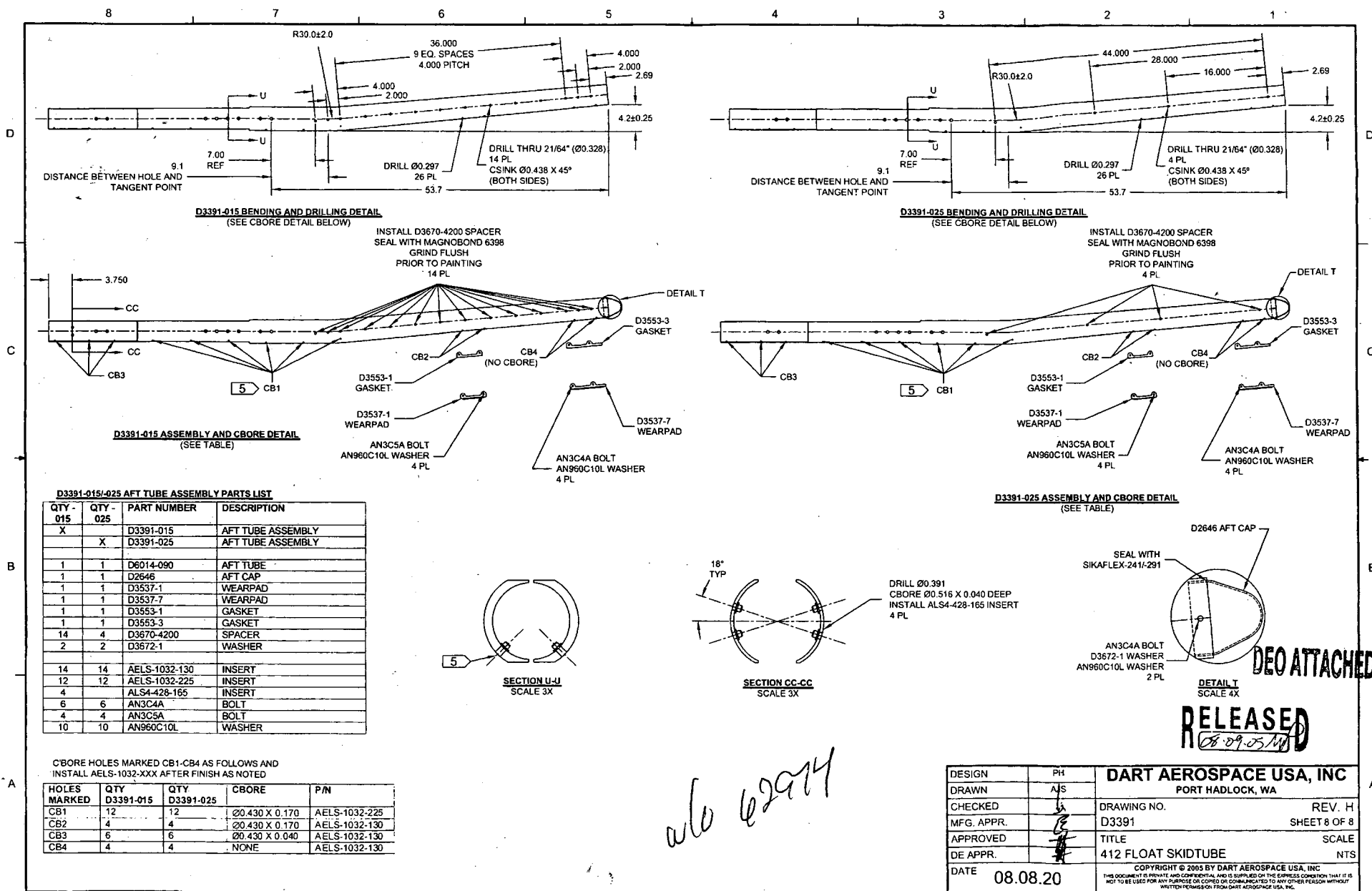
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NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN UP	CHECKED h	MFG. APPR. M	APPROVED MD	DE APPR. H	DATE 09/09/30		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MD

u/c 62974

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